

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026185**Date Inspected:** 24-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 19.

This QA Inspector observed ZPMC welder Mr. Ji Xiao Qiang, stencil 062783 used flux cored welding procedure WPS-B-T-2231-ESAB to make to make bikepath welds BK9003-A8-001-005, 008 and 066. This QA Inspector observed ZPMC QC has recorded a welding current of 302 amps and 25.7 volts. Mr. Ji Xiao Qiang appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 062806 used flux cored welding procedure WPS-B-T-2231-ESAB to make to make bikepath welds BK9003-A9-001-008, 068 and 069. This QA Inspector observed ZPMC QC has recorded a welding current of 297 amps and 26.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector performed random magnetic particle (MT) inspections of bikepath BK9003-A7-001-022, 029, 030, 039, 040, 045, 046; BK9003A6-001-178, 179 and 210 reference NWIT 9947 item 1. QA observed weld BK9003A7-001-023 was visually rejected due to insufficient weld size and weld overlap adjacent to where an

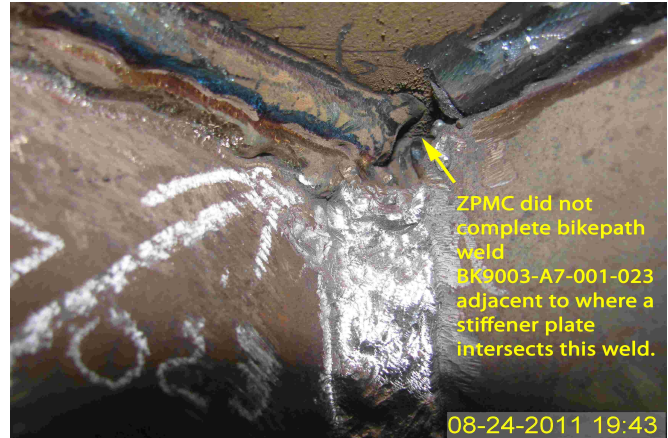
---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

adjacent stiffener is located and the other welds appear to comply with project specifications. ZPMC representative Mr. Huang You Gang was informed of the visual rejections and he told this QA Inspector that dayshift welders would perform repairs of this weld prior to notifying QA to perform reinspections of this weld. Dayshift Caltrans personnel were also informed of this visual rejection. For additional information on these inspections see this QA Inspector's TL6028 magnetic particle test report and the photographs below.



### Summary of Conversations:

See Above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

---